

Work Order ID 144829

April 25, 2016 3:25:27 PM

144829

Page 1

Item ID: D3560-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Weldment
 Start Date: 4/25/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/29/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Sat 20160425 Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3560	Rev D								

140 Weld per dwg A/R Aluminum rod Batch: 131562 000
 Large Fab

140

Large Fab

Large Fab

Memo

0.55

- 1-Weld assembly as per dwg D3560
 STEP:
 1- clean material (buff bracket and bottom of arm with blue pad)
 2- set up bracket and arm on jig
 3- preheat bracket and arm with torch
 4- clean before welding with brush
 5- set up machine to 135 amps
 6- weld across bottom and top ends
 7- reheat with torch (65 deg C)
 8- on one side weld from bottom to top half way
 9- same for other side (half way)
 10- from half way point weld the rest of the first side (ease off pedal near end)
 11- same for remaining side (ease off pedal near end)

1 **APR 26 2016** **DAS**
24
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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Work Order ID 144829

April 25, 2016 3:25:27 PM

144829

Page 4

Item ID: D3560-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Arm Weldment
Start Date: 4/25/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/29/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>WA3</u>	0.00							
210									
Packaging	Memo	0.01							
Packaging	*** STOCK IN STEP CELL*** LOCATION: WA003								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.10							
Quality Control									

APR 26 2016
MCS

APR 26 2016
MCS

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

April 25, 2016 3:25:31 PM

Page 1

Work Order ID: 144829

144829

Parent Item: D3560-042

D3560-042

Parent Item Name: Arm Weldment

Start Date: 4/25/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808 *D2808* Spacer		Manufactured	No				Each	21.0000		1			DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		21							
				109348		21							
D3560-2 *D3560-2* Arm		Manufactured	No				Each	0.0000		1			DAS 24 9-89
												APR 26 2016	
D3592-1 *D3592-1* Plate		Manufactured	No				Each	0.0000		1			DAS 24 9-89
												APR 26 2016	

**

16/04/16

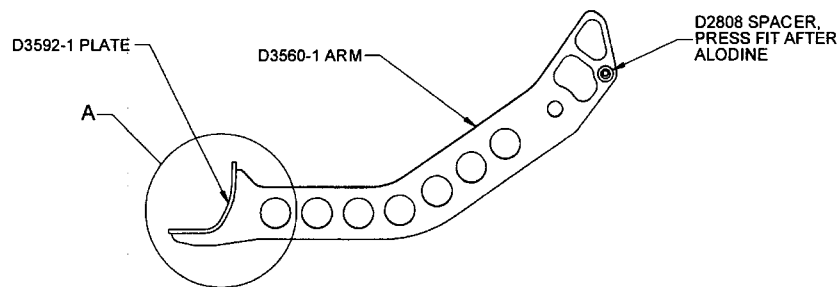
**

B142496 → 1

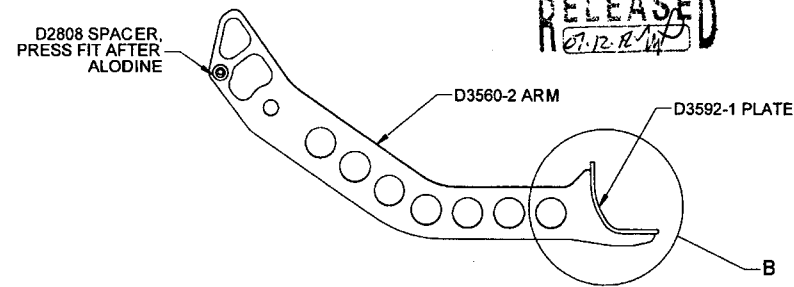
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B142862 → 1

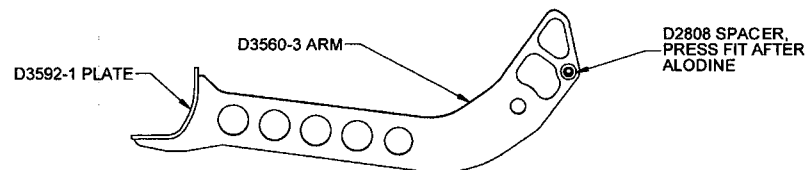
RELEASED
07.12.16



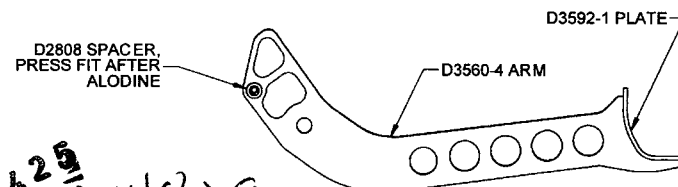
D3560-041 ARM WELDMENT



D3560-042 ARM WELDMENT

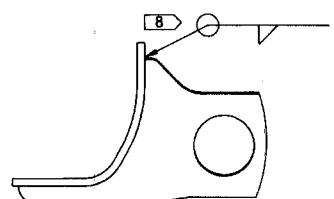


D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT

20160425
SA 144829



**DETAIL A
SCALE 1:2**

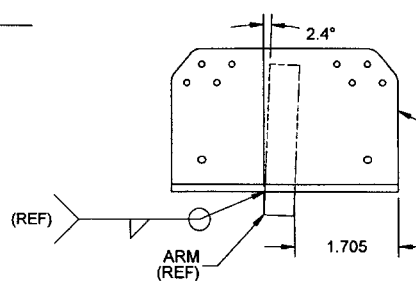
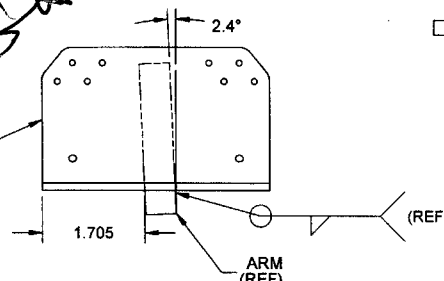
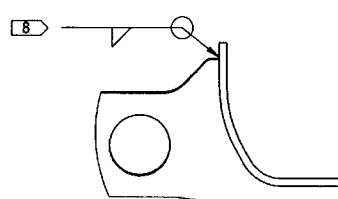


PLATE
(REF)



ARM
(REF)



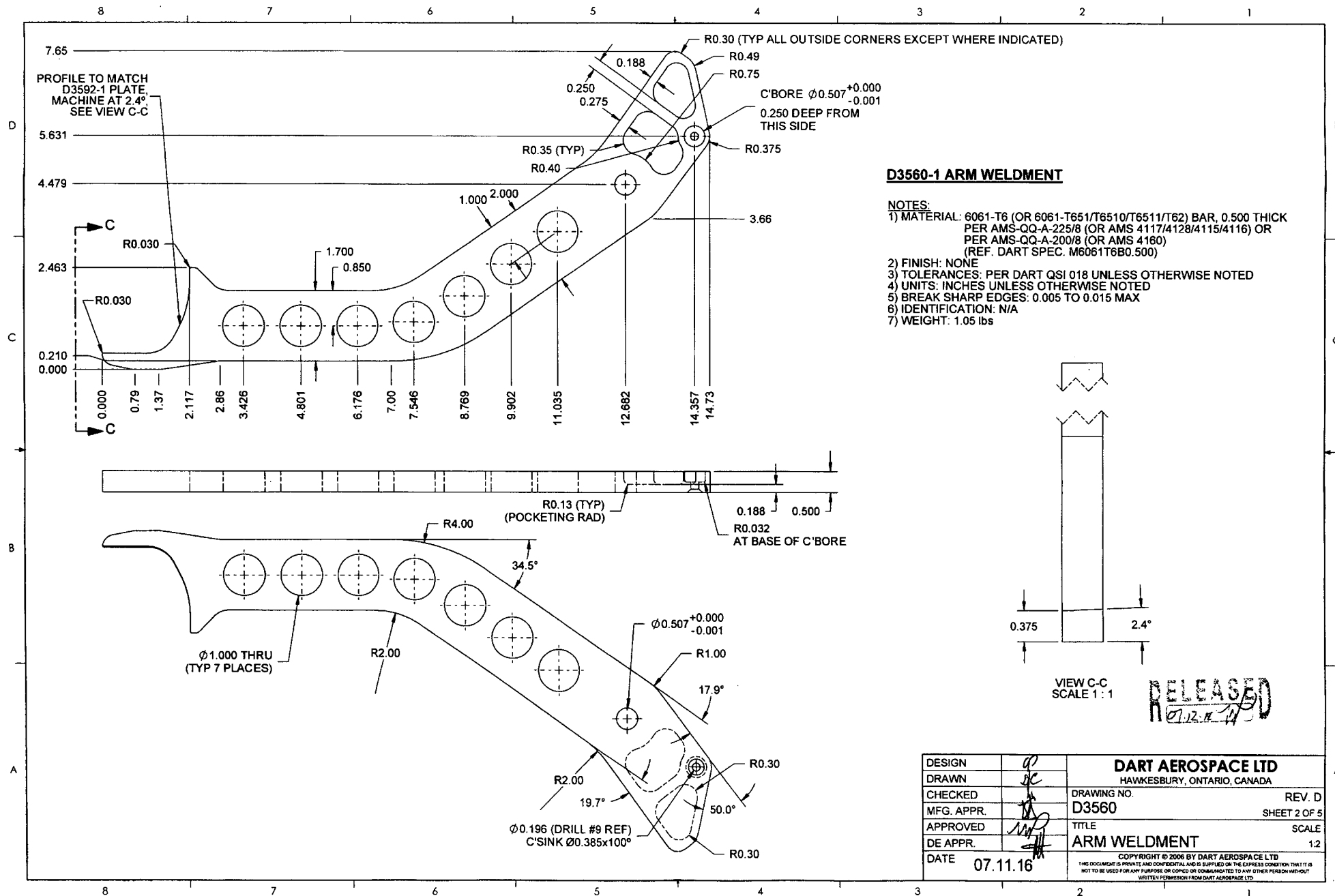
**DETAIL B
SCALE 1:2**

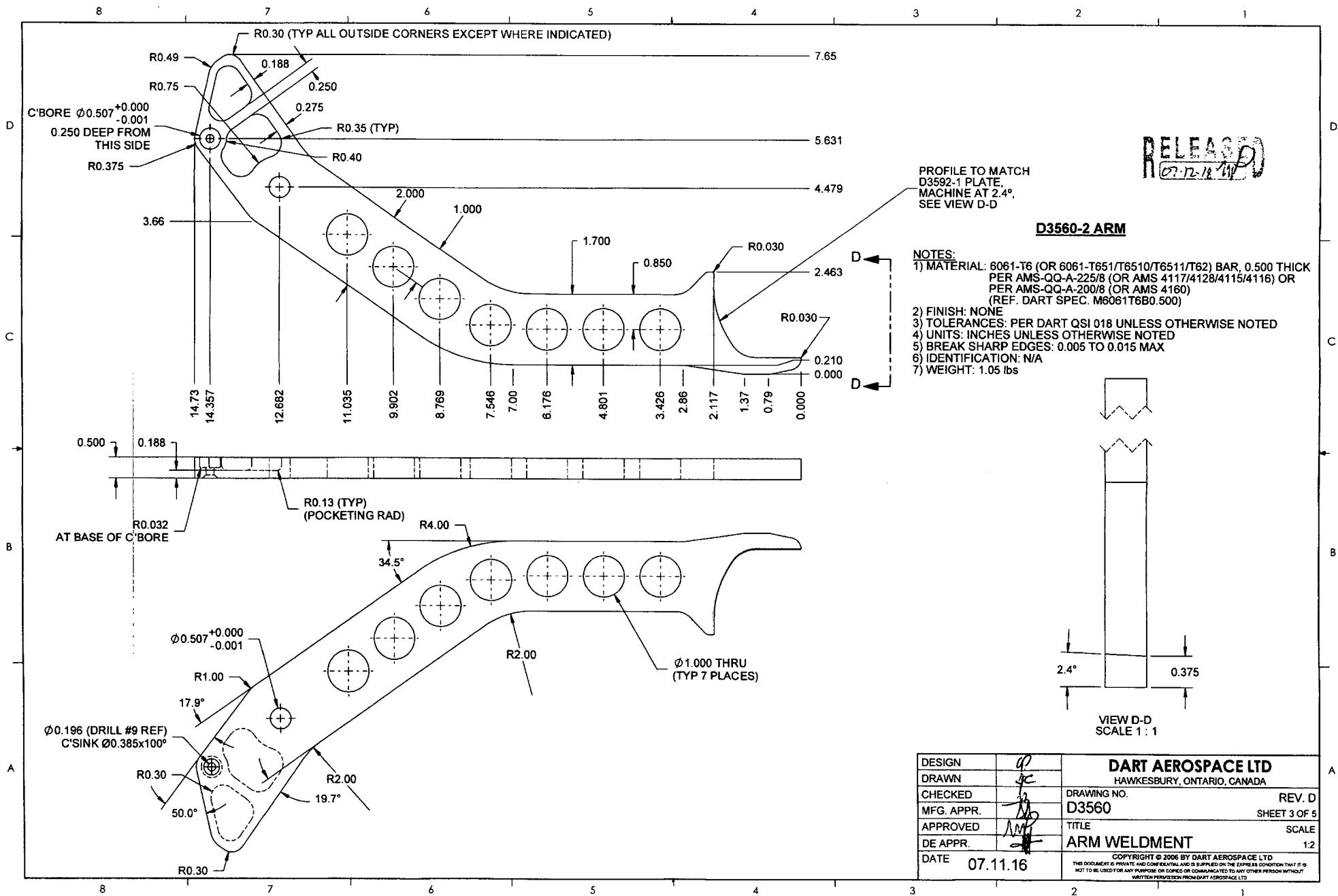
PARTS LIST

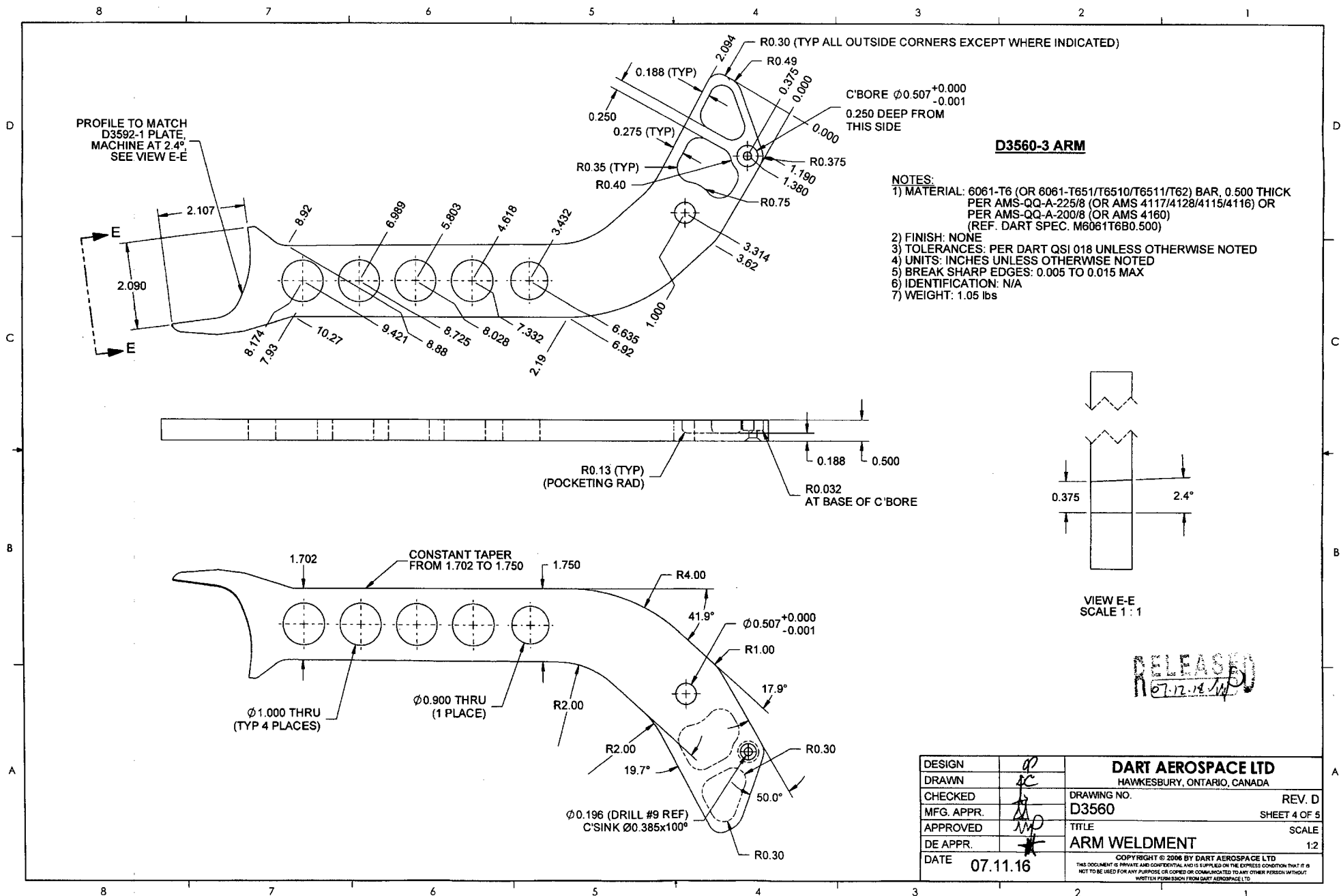
QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

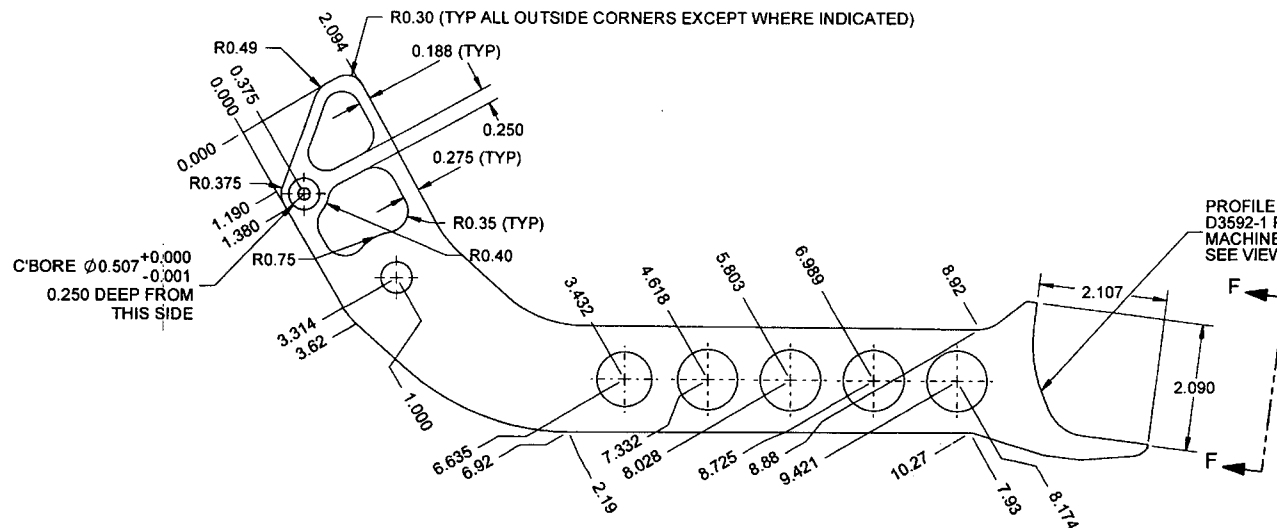
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.23 lbs (TYP)
 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3560 TITLE ARM WELDMENT SCALE 1:4 REV. D SHEET 1 OF 5 COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			





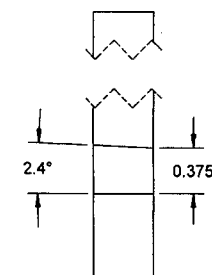
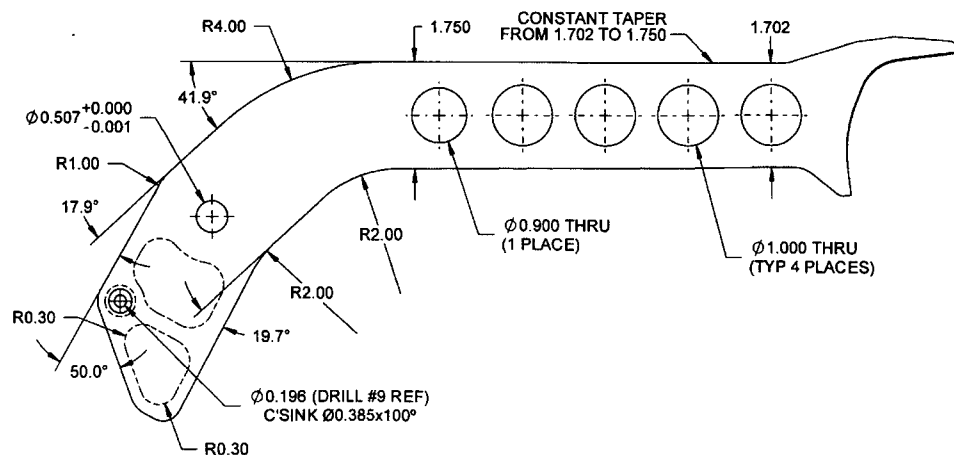
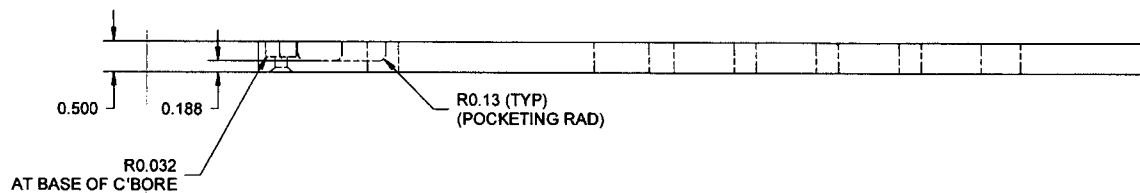




D3560-4 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

RELEASE
07-12-18

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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